

**Work Order ID 63295**

Wednesday, October 27, 2010 10:49:19 AM

Page 1

Item ID: D212-725-1-005

Accept

Setup Start

Revision ID:

Stop

Item Name: doubler

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:   N  Date: 10-10-27

Tooling:

Date:           

Run Start

QC:           Date:           SPC (Y/N):           Date:           

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:   B  Prog Rev:   B  

2-Deburr if necessary

10-10-284

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 63295

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Page 2

Item ID: D212-725-1-005

Accept



Setup Start



Revision ID:

Stop



Item Name: doubler

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

81011062



QC

Memo

0.00

Quality Control

\* See Attached Email For missing hubs \*

4

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 10/10/28

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 10/10/28

4 0

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63295**

Wednesday, October 27, 2010 10:49:19 AM

Page 3

Item ID: D212-725-1-005

Accept

Revision ID:

Item Name: doubler


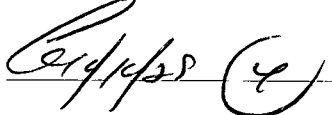

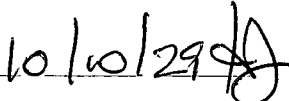
Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/30/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>383</u>  Memo	0.00  0.00							
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							 MF 10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 10:49:24 AM

Page 1

Work Order ID: 63295



Parent Item: D212-725-1-005



Parent Item Name: doubler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

103.8847

0.0312

0.131368



180-10-28

2024-T3 .050 sheet

## Location

## Loc Qty

## Loc Code

MAT22

103.8847

111381

11.89

113189

0.3947

114968

91.6

114968

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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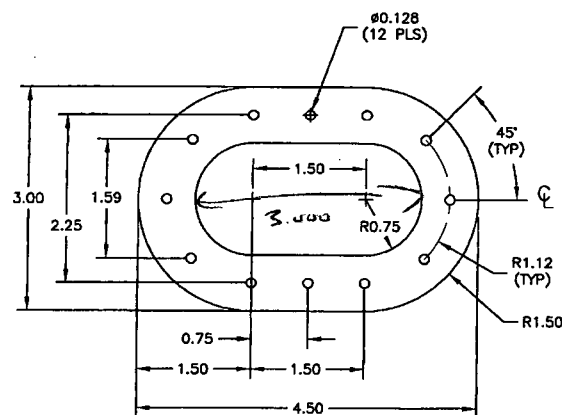
D212-728-1-048

X	First Article	X	Prototype
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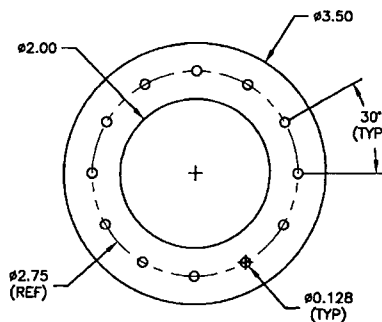
Measured by: B	Audited by: S	Prototype Approval:
Date: 10-10-28	Date: 10/10/28	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD

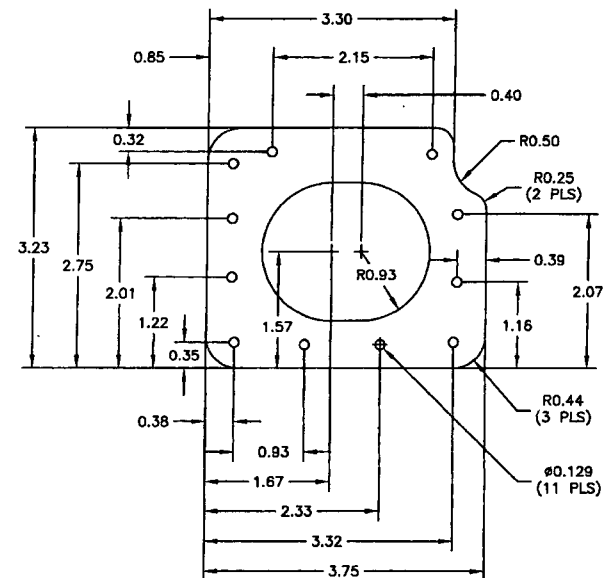
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43295  
B810-10-27



**D212-725-1-005 DOUBLER**



**D212-725-1-017A DOUBLER**



**D212-725-1-017B DOUBLER**

RELEASED  
2009-10-28  
WV

**D212-725-1-005/-017A/-017B NOTES:**

- 1) MATERIAL: 2024-T3 (00-A-250/4) 0.050 ALUMINUM SHEET (REF. DART SPEC. M2024T3S0.050)
- 2) FINISH: ACID ETCH, ALODINE 1208 OR 1204 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN DS	DRAWN BY RF	<b>DART</b> DART AEROSPACE LTD HAMPSHIRE, ENGLAND, UK
CHECKED DS	APPROVED [Signature]	DRAWING NO. D212-725-1
DATE 07.05.11		REV. B SHEET 3 OF 44 SCALE NTS

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**L Lacelle**

**From:** Robert Fuentes [rfuentes@dartaero.com]

**Sent:** October 27, 2010 1:03 PM

**To:** 'L Lacelle'

**Cc:** 'H. Siemeris'; 'David Shepherd'

**Subject:** RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

**From:** L Lacelle [mailto:llacelle@dartaero.com]

**Sent:** Wednesday, October 27, 2010 9:47 AM

**To:** 'Robert Fuentes'

**Cc:** 'H. Siemens'; 'David Shepherd'

**Subject:** FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the drwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

**From:** David Duval [mailto:dduval@dartaero.com]

**Sent:** October 27, 2010 11:43 AM

**To:** Linda Lacelle

**Subject:**

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

**David Duval**

*Production Engineering Coordinator*



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200

dduval@dartaero.com



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10/27/10